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(54) Title: SOLUBLE MATERIAL AND PROCESS FOR THREE-DIMENSIONAL MODELING			
(57) Abstract			
<p>A process for three-dimensional modeling in which an alkali-soluble thermoplastic material is used in an additive deposition process to form a soluble support structure (28) for a three-dimensional object (26) under construction. The alkali-soluble thermoplastic material includes a base polymer of carboxylic acid and a plasticizer. Following formation, the object (26) is placed in an alkaline bath to dissolve the support structure (28). The alkali-soluble material can be used to form an alkali-soluble three-dimensional object (26).</p>			